

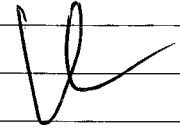
# Work Order ID 147908

Wednesday, June 22, 2016 8:42:36 AM

**\*147908\***

Page 1

Item ID: D3405-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Ground Handling Lug  
 Start Date: 6/21/2016 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 7/4/2016 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan:  Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                                                                  | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|-------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr                                                                              |                      |         |        |              |               |               |                  |                |
| D3405                          | Rev B                                                                                     |                      |         |        |              |               |               |                  |                |
| 100                            | FLOW WATER JET                                                                            | 0.00                 |         |        |              |               |               |                  |                |
| <b>*100*</b>                   |                                                                                           |                      |         |        |              |               |               |                  |                |
| Waterjet                       | Memo                                                                                      | 0.13                 |         |        |              |               |               |                  |                |
| FLOW CNC Waterjet              | 1-Cut as per Dwg D3405<br>Dwg Rev: <u>B</u><br>Prog Rev: <u>B</u><br>2-Debur if necessary |                      |         |        |              |               |               |                  |                |
| 110                            | QC2- Inspect parts off machine FAI/FAIB                                                   | 0.00                 |         |        |              |               |               |                  |                |
| <b>*110*</b>                   |                                                                                           |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                                                                      | 0.03                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                                                           |                      |         |        |              |               |               |                  |                |
| 120                            | QC8- Inspect parts - second check                                                         | 0.00                 |         |        |              |               |               |                  |                |
| <b>*120*</b>                   |                                                                                           |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                                                                      | 0.03                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                                                           |                      |         |        |              |               |               |                  |                |

⑧ \_\_\_\_\_ DC 16/06/29

⑧ \_\_\_\_\_ DC 16/06/29

⑧ \_\_\_\_\_ JUL 05 2016

DAS  
38  
9-88



**\*1 47908\***

Wednesday, June 22, 2016 8:42:36 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*g\***

**Cust Item ID:**

**\*g\***

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---------------|---------------|------------------|----------------|
|---------------|---------------|------------------|----------------|

8 AUG 10 2016 DAS 24 9:09

**\*160\***

QC

## Memo

0.03

## Quality Control

0.00

**\*170\***

OC

## Memo

0.03

## Quality Control

White Gloss(Ref:4.3.5.1) per CSI005 4.3-Alum

0.00

**\*180\***

Powdercoat

## Powder Coating

## Memo

START TIME:

OVEN TEMPERATURE:

**FINISH TIME:**

0.04

**Work Order ID 147908**

Wednesday, June 22, 2016 8:42:36 AM

**\*147908\***

Page 4

Item ID: D3405-043

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Ground Handling Lug

Start Date: 6/21/2016 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 7/4/2016 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp            |
|--------------------------------|---------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|---------------------------|
| 190                            | QC3- Inspect Part Finish                    | 0.00                 |         |        |              |               |               |                  |                           |
| <b>*190*</b>                   |                                             |                      |         |        |              |               |               |                  |                           |
| QC                             | Memo                                        | 0.03                 |         |        |              |               |               |                  | DAS<br>38<br>AUG 1 8 2016 |
| Quality Control                |                                             |                      |         |        |              |               |               |                  |                           |
| 200                            | Identify as per dwg & Stock Location        | 0.00                 |         |        |              |               |               |                  |                           |
| <b>*200*</b>                   |                                             |                      |         |        |              |               |               |                  |                           |
| Packaging                      | Memo                                        | 0.13                 |         |        |              |               |               |                  | DAS<br>6<br>9-89          |
| Packaging                      |                                             |                      |         |        |              |               |               |                  |                           |
| 210                            | QC21- Final Inspection - Work Order Release | 0.00                 |         |        |              |               |               |                  |                           |
| <b>*210*</b>                   |                                             |                      |         |        |              |               |               |                  |                           |
| QC                             | Memo                                        | 0.01                 |         |        |              |               |               |                  | DAS<br>21<br>9-89         |
| Quality Control                |                                             |                      |         |        |              |               |               |                  |                           |

AUG 1 8 2016

AUG 1 8 2016

CMF

16-8-18

# Picklist Print

Wednesday, June 22, 2016 8:42:35 AM

Page 1

Work Order ID: 147908

**\*147908\***

Parent Item: D3405-043

**\*D3405-043\***

Parent Item Name: Ground Handling Lug

Start Date: 6/21/2016

Required Date: 7/4/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A05.09.01New issueKJ/JLM  
IPP B 09.01.28 Rev b dwg EC verified by: DD

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

|         |  |              |    |  |  |     |      |         |   |   |  |  |  |
|---------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D3404-1 |  | Manufactured | No |  |  | 100 | Each | 82.0000 | 1 | 8 |  |  |  |
|---------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|

**\*D3404-1\***

GHW/ Lug

**\*\***

16-08-09  
JBL

Location

Loc Qty

Loc Code

WA001

82

142472

2

145962

80

|           |  |           |    |  |  |     |    |         |       |          |  |  |  |
|-----------|--|-----------|----|--|--|-----|----|---------|-------|----------|--|--|--|
| M304S11GA |  | Purchased | No |  |  | 150 | sf | 94.4249 | 0.154 | 1.296842 |  |  |  |
|-----------|--|-----------|----|--|--|-----|----|---------|-------|----------|--|--|--|

**\*M304S11GA\***

304/316 0.125 Sheet

**\*\***

on 16/06/29

Location

Loc Qty

Loc Code

MAT020

68.18998

M129545

31.99998

M129972

23.5

M134284

12.69

TPI

26.234932

M134604

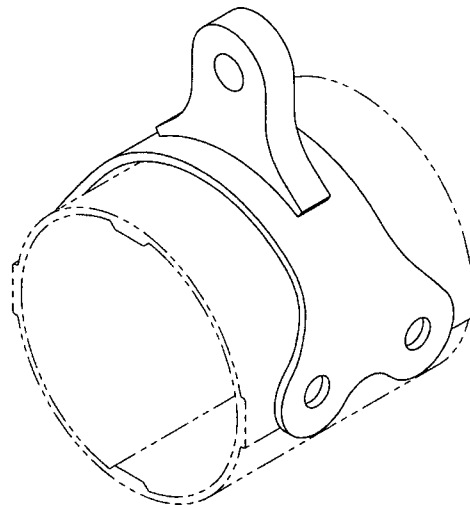
26.234932



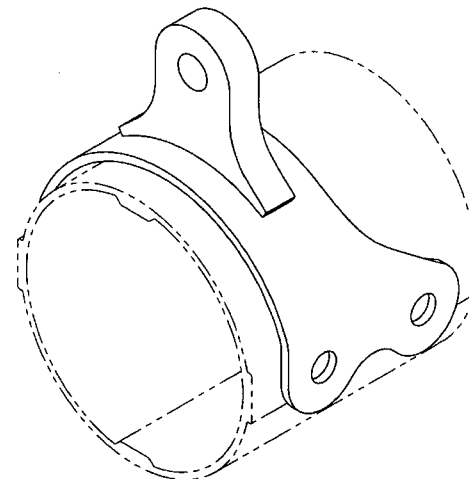
| ITEM No. | QTY. -041 | QTY. -043 | PART NUMBER | DESCRIPTION  |
|----------|-----------|-----------|-------------|--------------|
| 1        | X         |           | D3405-041   | LUG ASSEMBLY |
| 2        |           | X         | D3405-043   | LUG ASSEMBLY |
| 11       | 1         | 1         | D3404-1     | GHW LUG      |
| 12       | 1         |           | D3405-1     | GHW BRACKET  |
| 13       |           | 1         | D3405-3     | GHW BRACKET  |

△B

STUDY COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 147-908 MLJ  
16-06-17



**D3405-041 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)



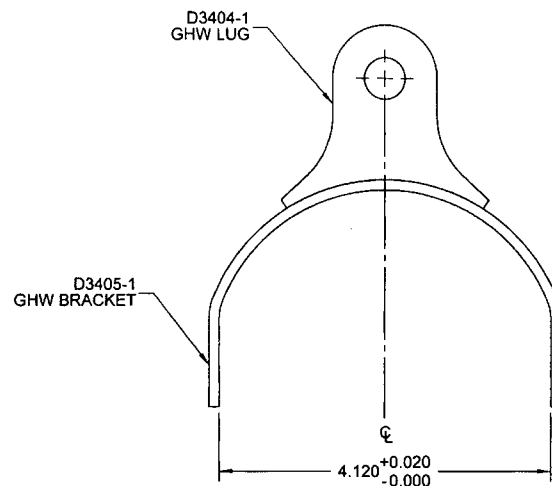
**D3405-043 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)

**RELEASED**  
08/12/18 MJP

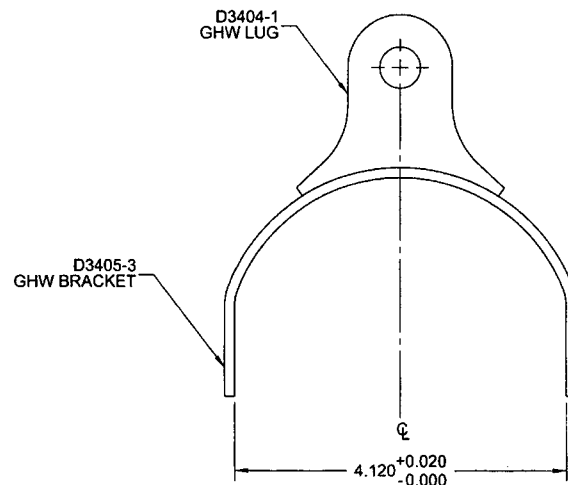
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER  
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs  
-043, 0.87 lbs

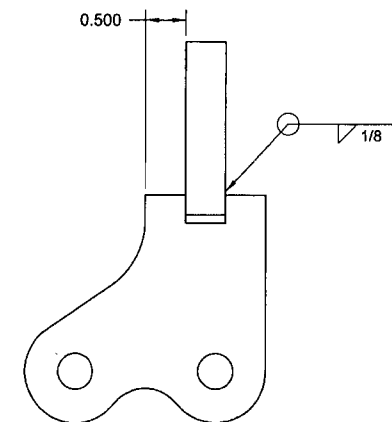
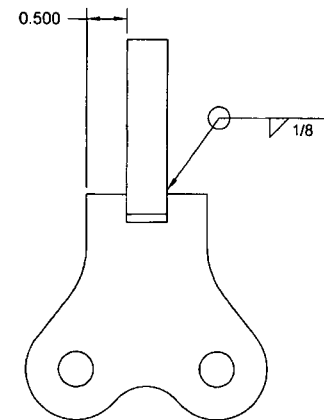
|            |                                                                                                                                                                                                                            |                                                                                                                                                                                                                                                                          |              |          |
|------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|----------|
| B          | DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100. |                                                                                                                                                                                                                                                                          | AJS          | 08.09.19 |
| A          | NEW ISSUE                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                          | PH           | 05.03.08 |
| REV.       | DESCRIPTION                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                          | BY           | DATE     |
| DESIGN     | PH                                                                                                                                                                                                                         | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                 |              |          |
| DRAWN      | AJS                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                          |              |          |
| CHECKED    |                                                                                                                                                                                                                            | DRAWING NO.                                                                                                                                                                                                                                                              | REV. B       |          |
| MFG. APPR. |                                                                                                                                                                                                                            | D3405                                                                                                                                                                                                                                                                    | SHEET 1 OF 4 |          |
| APPROVED   |                                                                                                                                                                                                                            | TITLE                                                                                                                                                                                                                                                                    | SCALE        |          |
| DE APPR.   |                                                                                                                                                                                                                            | GHW LUG ASSEMBLY                                                                                                                                                                                                                                                         | NTS          |          |
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**D3405-041 LUG ASSEMBLY**



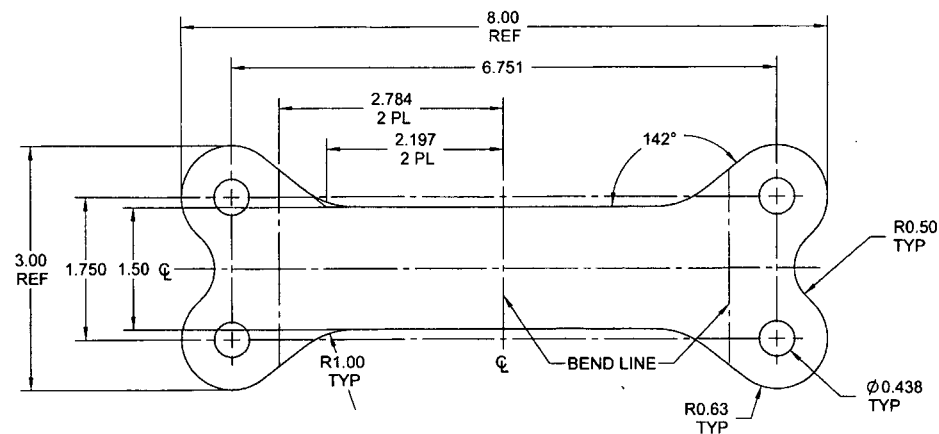
**D3405-043 LUG ASSEMBLY**



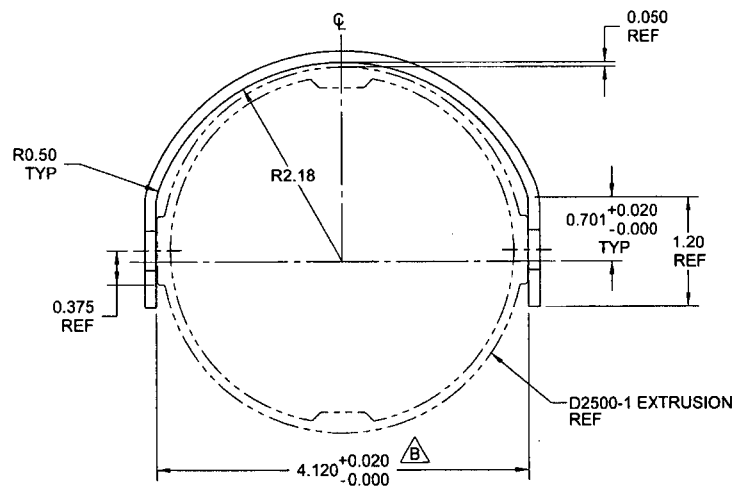
**RELEASED**  
06/12/18 M/T

|            |          |                                                                                                                                                                                                                                                                                          |        |
|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|
| DESIGN     | PH       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                 |        |
| DRAWN      | AJS      |                                                                                                                                                                                                                                                                                          |        |
| CHECKED    |          | DRAWING NO. D3405                                                                                                                                                                                                                                                                        | REV. B |
| MFG. APPR. |          | SHEET 2 OF 4                                                                                                                                                                                                                                                                             |        |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                                    | SCALE  |
| DE APPR.   |          | GHW LUG ASSEMBLY                                                                                                                                                                                                                                                                         | NTS    |
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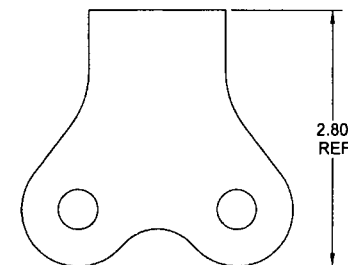




**D3405-1F GHW BRACKET FLAT PATTERN**



**D3405-1 GHW BRACKET**  
(MAKE FROM D3405-1F)



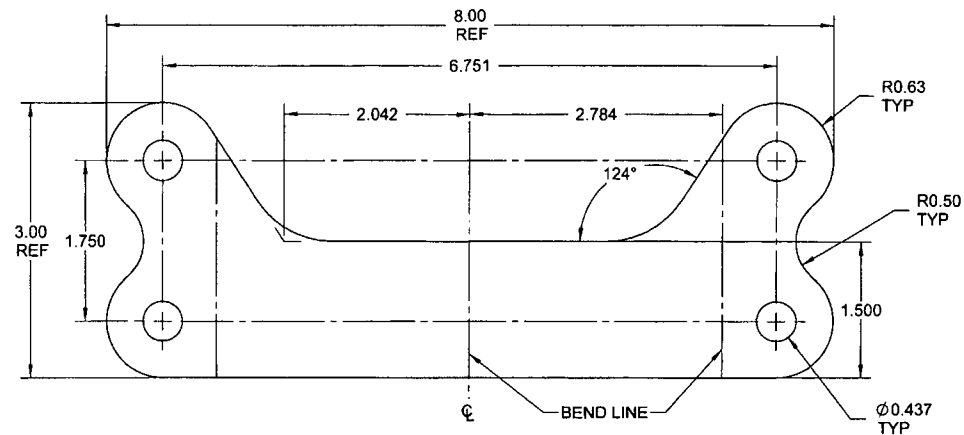
SIDE VIEW FOR REF ONLY

**NOTES:**

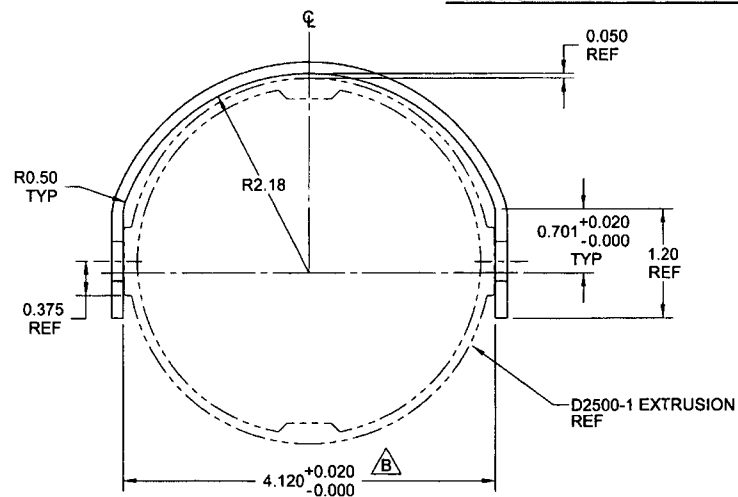
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

|            |          |                                                                                                                                                                                                                                                                |              |
|------------|----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | PH       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                       |              |
| DRAWN      | AJS      |                                                                                                                                                                                                                                                                |              |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                    | REV. B       |
| MFG. APPR. |          | D3405                                                                                                                                                                                                                                                          | SHEET 3 OF 4 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                          | SCALE        |
| DE APPR.   |          | GHW LUG ASSEMBLY                                                                                                                                                                                                                                               | NTS          |
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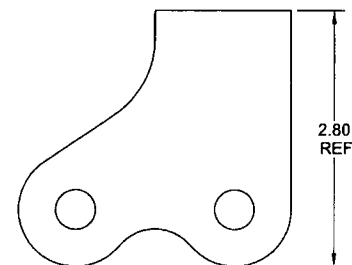
**RELEASED**  
MP 08/12/18



**D3405-3F GHW BRACKET FLAT PATTERN**



**D3405-3 GHW BRACKET**  
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

**RELEASED**  
08/12/18

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

|            |          |                                                                                                                                                                                                                                                                                |              |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | PH       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                       |              |
| DRAWN      | AJS      |                                                                                                                                                                                                                                                                                |              |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                    | REV. B       |
| MFG. APPR. |          | D3405                                                                                                                                                                                                                                                                          | SHEET 4 OF 4 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                          | SCALE        |
| DE APPR.   |          | GHW LUG ASSEMBLY                                                                                                                                                                                                                                                               | NTS          |
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